Technical Data Sheet

Permatex® Bearing Mount for Close Fits

AAM Revised 09/14

PRODUCT DESCRIPTION

Permatex® Bearing Mount for Close Fits is a general purpose, low viscosity, single component anaerobic retaining adhesive for cylindrical joints. It is a green colored liquid resin, which hardens and cures in the absence of air. Permatex® Bearing Mount for Close Fits self-hardens into a tough plastic material when it is confined between close-fitting metal parts. The cured adhesive is a thermoset plastic suitable for exposure to most solvents and engine fluids. OEM Specified. Meets or exceed the requirements of Military Specification Mil-R-46082B, Type I.

PRODUCT BENEFITS

- No mixing
- No curing outside of joint
- Prevents fretting and corrosion
- Allows the use of slip fit or press fit
- For use on assemblies with gaps up to 0.005" diametral

TYPICAL APPLICATIONS

- Used to bond cylindrical fitting parts
- Bushings
- Bearings
- Oil seals
- Ring gear bolts
- Differential lock pin

DIRECTIONS FOR USE

1. Remove any grease or oil by using Permatex® Brake & Parts Cleaner.
2. For slip fitted assemblies, apply adhesive around the leading edge of the collar and use a rotating motion during assembly.
3. For press fits, adhesive should be applied thoroughly to both bond surfaces and assembled at high press-on rates.
4. For shrink fitted assemblies, the adhesive should be coated onto the pin; the collar should then be heated to create sufficient clearance for free assembly.
5. For faster cure rates, use Permatex® Surface Prep on both surfaces.
6. Parts should not be disturbed until sufficient handling strength is achieved.
7. Any material that is on the outside of the assembly will not cure. Wipe off with a dry cloth.

PROPERTIES OF UNCURED MATERIAL

	Typical Value
Chemical Type	Anaerobic dimethacrylate ester
Appearance	Green liquid
Specific Gravity @ 77ºF	1.1
Viscosity, cps	110 - 140
Flash Point, COC, ºF	>200°
Cure Speed	Hardens in 4 hours Full cure in 24 hours

For Cleanup

1. Residual liquid films outside the joints are readily soluble in Permatex® Brake & Parts Cleaner.
2. Cured product can be removed with a combination of soaking in Permatex® Gasket Remover and mechanical abrasion such as a wire brush.

For Disassembly

1. Apply localized heat to assembly to approximately 232°C (450°F). Disassemble while hot.

For Reassembly

1. Remove any loose product from the assembly.
2. Apply primer to mating parts.
3. Assemble as per directions.

PERFORMANCE OF CURED MATERIAL

Temperature Resistance - -65°F to 300°F
Corrosivity - None (Slightly acidic, may discolor some metals.)
Dielectric Strength - 250 volts/mil

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

ORDERING INFORMATION

Part Number	Container Size
60950	50 ml bottle, carded

STORAGE

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° to 28°C (46° to 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container.

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